

Date: Wednesday, 12/5/2007 10:24:41 AM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SHUT-OFF VALVE SHAFT |
| Job Number | : 36125 | | |
| Estimate Number | : 12180 | | |
| P.O. Number | : N/A | Part Number | : D34705 |
| This Issue | : 12/5/2007 S.O. No. : N/A | Drawing Number | : D3470 REV.A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : PURCHASED PARTS | Drawing Revision | : A |
| Previous Run | : 34411 | Material | : N/A |
| Written By | : <u>12/07/12 05</u> | Due Date | : 12/12/2007 |
| Checked & Approved By | : <u>12/07/12 05</u> | Qty: | 13 Um: Each |
| Comment | : est rev A 06.04.20 new issue EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|---------------------|
| 1.0 | M304S26GA | 304/316 0.018 SHEET |
|-----|-----------|---------------------|



8528



Comment: Qty.: 0.0656 sf(s)/Unit Total : 0.6563 sf(s)
 304/316 0.018 SHEET Batch: 105591 12-07-12-7

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 Cut as per Dwg D3470
 Dwg Rev: A
 Prog Rev: A

12-07-12-7

13

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

6/12/10 (x13) center

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary.

mf

07-12-10

13

| | | |
|-----|-----|------------------------------|
| 6.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

6/12/10 (x13)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 9/12/11
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 10:24:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE SHAFT

Job Number: 36125

Part Number: D34705

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BA

mf

07-12-10

(13)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(13)

Comment: FINAL INSPECTION/W/O RELEASE

DA/12/11

Job Completion



run 2007/12/11 cy

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

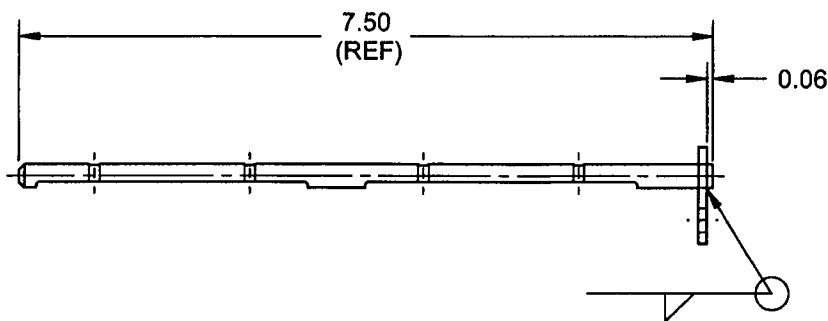
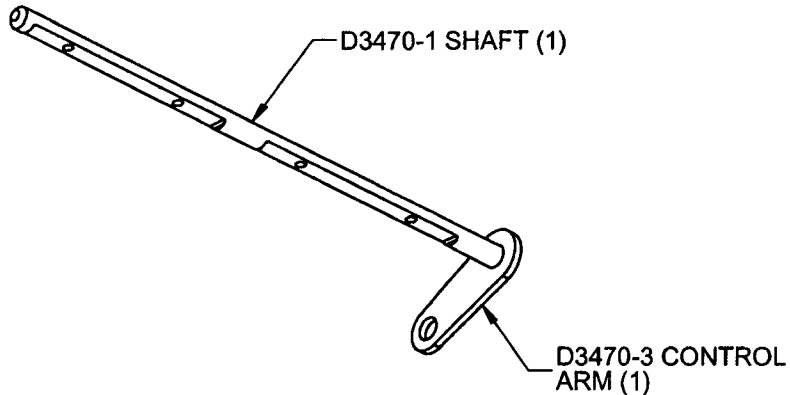
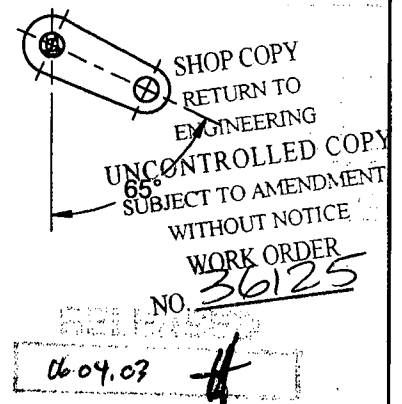
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|-------------------------------|--------------------------------|--|------------------------|
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3470 | REV. A SHEET 1 OF 4 |
| DATE 05.12.14 | | TITLE SHUT-OFF VALVE SHAFT | SCALE 1:2 |
| A | 05.12.14 | NEW ISSUE | |

**D3470-041 SHUT-OFF VALVE SHAFT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY -041 | P/N | DESCRIPTION |
|-------------|-----------|----------------------|
| X | D3470-041 | SHUT-OFF VALVE SHAFT |
| 1 | D3470-1 | SHAFT |
| 1 | D3470-3 | CONTROL ARM |

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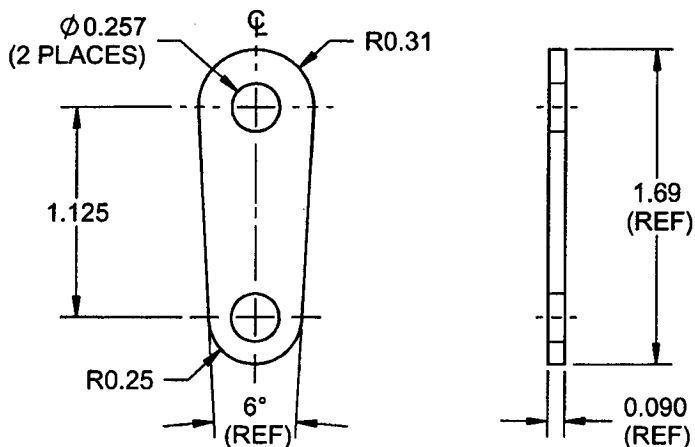
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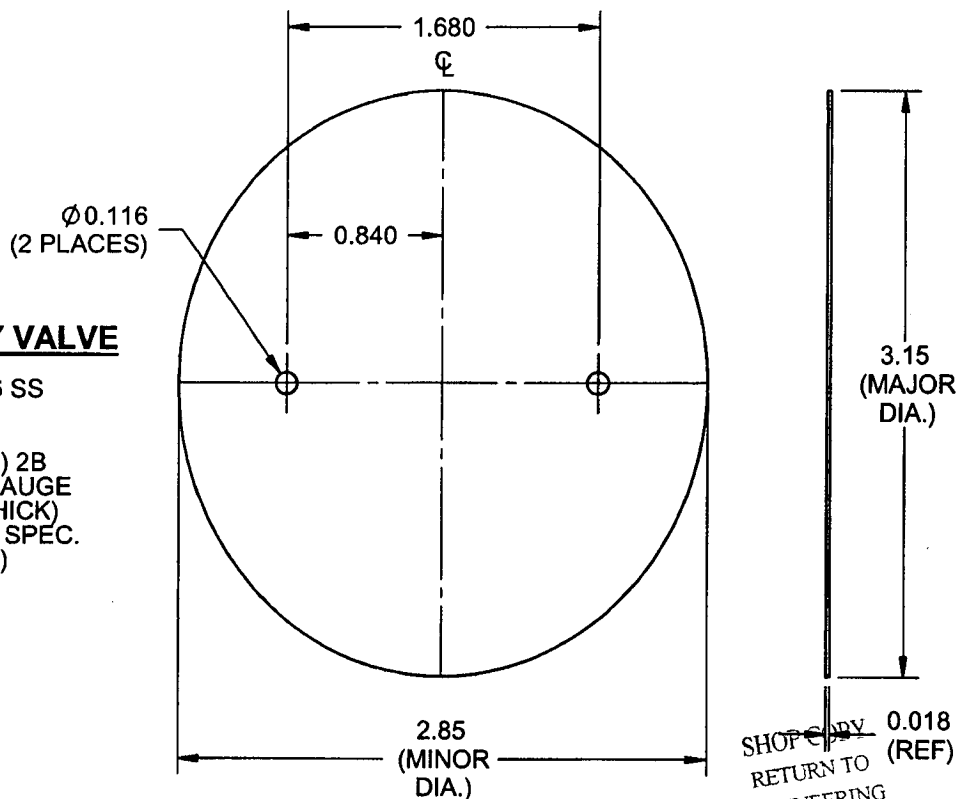
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| DATE 05.12.14 | | TITLE SHUT-OFF VALVE SHAFT | |
| | | SCALE 1:1 | |

D3470-3 CONTROL ARM

- 1) MATERIAL: AISI 304/316 SS SHEET PER
MIL-S-5019 (ANNEALED) 2B
FINISH 13 GAUGE SS
(0.090 THICK)
(REF. DART SPEC. M304S13GA)

**D3470-5 BUTTERFLY VALVE**

- 1) MATERIAL: AISI 304/316 SS
SHEET PER
MIL-S-5019
(ANNEALED) 2B
FINISH 26 GAUGE
SS (0.018 THICK)
(REF. DART SPEC.
M304S26GA)

**NOTES:**

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

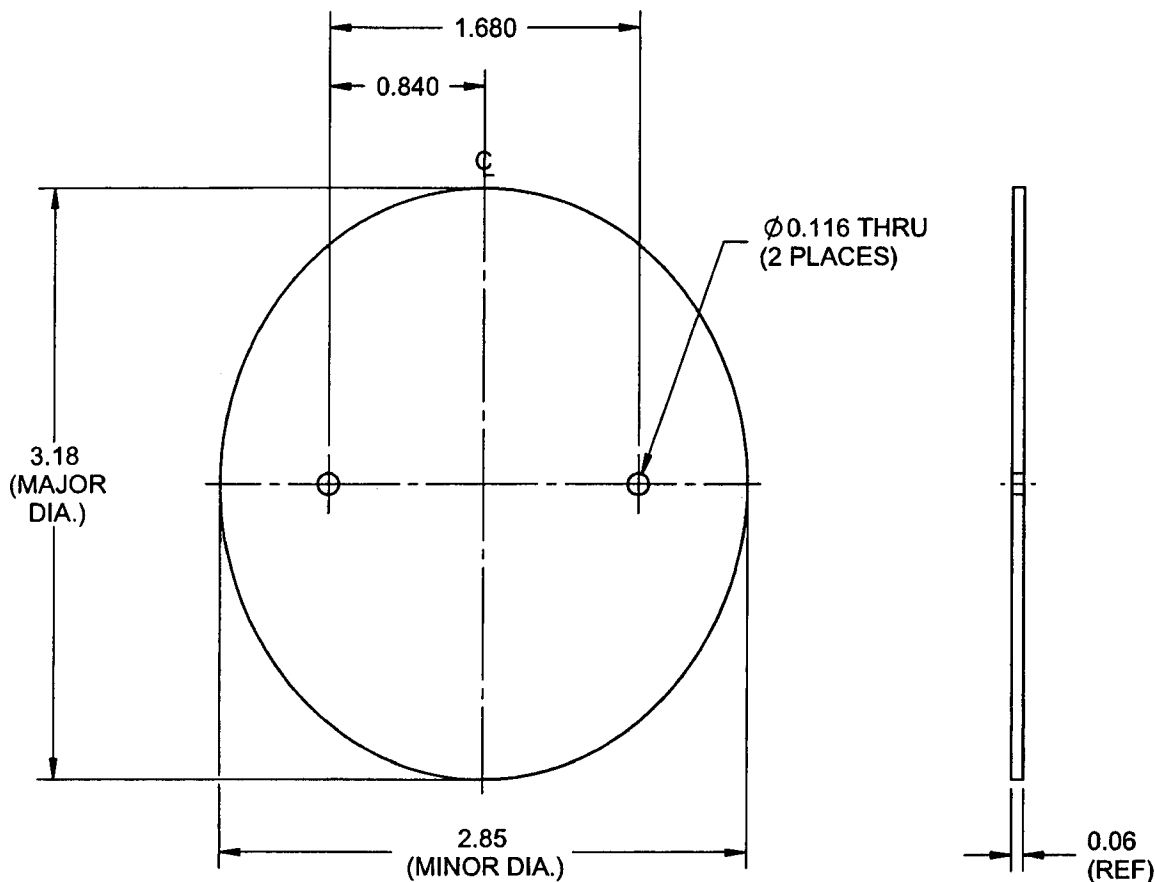
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3470 | REV. A SHEET 4 OF 4 |
| DATE 05.12.14 | | TITLE SHUT-OFF VALVE SHAFT | SCALE 1:1 |



D3470-7 BUTTERFLY VALVE SEAL

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
06.04.03 *[Signature]*

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